

TEXAS UTILITIES GENERATING CO. CPSIES	INSTRUCTION NUMBER	REVISION	ISSUE DATE	PAGE
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INSPECTION OF SPECIAL COATING OPERATIONS	PREPARED BY: <u>J. P. Hasty</u> <u>7-26-79</u> Date			
	APPROVED BY: <u>James L. [Signature]</u> <u>7-26-79</u> Date			

1.0 REFERENCES

1-A QP-11.4, "Inspection of Protective Coatings"

2.0 GENERAL

This Instruction will supplement the requirements of Ref. 1-A for inspection of special coatings. Inspections shall be documented on the Special Coatings Operation Checklist (Figure 1).

3.0 INSTRUCTION

3.1 QUALIFICATIONS

The Inspector shall verify (by Qualification Record or list of qualified applicators from QA file) that the coating applicators on each shift are qualified for safety-related coating work.

3.2 PREPARING COATING MATERIAL VERIFICATION

3.2.1 Coating Materials Identification

The Inspector shall inspect the coating material containers prior to mixing contents for product identification and verify that materials are correct for special coating procedure application.

3.2.2 Special Coating Mixes

The Inspector shall witness each mixing/thinning operation.

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3.3 PRE-APPLICATION OPERATIONS

3.3.1 Ambient Conditions

Ambient conditions/surface temperatures are acceptable for application or surface preparation. The Inspector shall determine air temperature, relative humidity and dew point. A calibrated humidity recorder (Bristol 4069 TH or equivalent) shall be used for air temperature determination. A calibrated non-mercury filled wet bulb thermometer or a calibrated humidity recorder (Bristol 4069 TH or equivalent) shall be used to determine relative humidity. The dew point shall be determined by the difference in dry and wet bulb temperatures using the U.S. Department of Commerce Weather Bureau Psychrometric Tables, W.B. No. 235. The surface temperature shall be determined by placing a calibrated surface temperature thermometer (Omega-Amprobe Fastemp, Range 10-150°F thermometer or equivalent) in contact with the surface. The thermometer probe shall remain in contact with the surface until the temperature reading stabilizes.

A. Manufacturer's Data Information

B. 35-1195-CCP-30; Special Coating Procedure requirements

3.4 SPECIAL COATINGS APPLICATION

3.4.1 Procedural Compliance

The Inspector shall verify that all application steps of the "Special Coating Procedure" are accomplished.

3.4.2 Dry Film Thickness (DFT)

~~The Inspector shall perform a DFT inspection of the cured coating film~~ in accordance with SSPC-PA2-73T. A calibrated 0-25 mil Elcometer Inspector DFT gage, model 111/1E or equivalent, shall be used. The DFT data will be averaged as described in SSPC-PA2-73T for each 100 (approx.) square foot area. Areas of 40 square feet or less shall have a minimum of two spot readings taken and averaged.

A. Manufacturer's Data Information

B. 35-1195-CCP-30, "Special Coating Procedure" requirements.

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3.4.3 Visual Defects Inspection

The Inspector shall perform a visual inspection of the coated surface for the following defects:

- a. Runs/sags
- b. Skips/holidays
- c. Dry spray
- d. Overspray
- e. Contamination
- f. Pinholes
- g. Discontinuities

Criteria:

- A. Manufacturer's Data Information

3.4.4 Coating Cure

The Inspector shall monitor ambient conditions (temperature, humidity) after the coating is applied to determine when "tack free" and when cure is adequate for any further coating operations to commence. A calibrated wet bulb/dry bulb thermometer, calibrated temperature/humidity recorder, or local weather station data may be used.

3.5 FINAL ACCEPTANCE

The Inspector shall determine that all FDRs and NCRs are complete prior to signing and dating Final Acceptance on checklist.

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FIGURE 1

QUALITY ASSURANCE DEPARTMENT
SPECIAL COATINGS OPERATION CHECKLIST

PROJECT CPSES

UNIT _____

~~PREAPPLICATION OPERATIONS~~

1. Ambient conditions acceptable for coating application.
2. Surface acceptable for coating application.
- *3. Air supply acceptable for coating application.

_____	_____	_____
_____	_____	_____

FINISH COAT APPLICATION OPERATIONS

1. Surveillance inspection during finish coat application.
2. "Special Coating Procedure" status accomplished.

_____	_____	_____
_____	_____	_____

~~CONFIRM-POST APPLICATION OPERATIONS~~

- *1. Visual Defects Inspection
- *2. Dry film thickness Min. _____ Max. _____ Avg. _____
- *3. Coating continuity inspection
4. Touch-up operations
5. Coating cure

_____	_____	_____
_____	_____	_____
_____	_____	_____

COMMENTS:

FINAL ACCEPTANCE:

(Signature of Engineer/Inspector)

DATE _____

- ☒ Satisfactory
- ☐ Unsatisfactory
- Inspection held pending

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FIGURE 1
CONTINUED

QUALITY ASSURANCE DEPARTMENT
SPECIAL COATINGS OPERATION CHECKLIST

PROJECT CPSES

BUILDING _____
LOCATION _____
UNIT _____

TIME OF DAY	TEMPERATURE			RELATIVE HUMIDITY	DEW POINT	SKY	WIND		PRECIP
	DRY BULB	WET BULB	SURFACE				DIR	VEL	
<u>GENERAL</u>						<u>RESULTS</u>	<u>INITIAL</u>	<u>DATE</u>	
1. Construction Procedure approved. (Attachment 4)						_____	_____	_____	
2. Coating applicators name _____						_____	_____	_____	
<u>MIXING/MATERIAL VERIFICATION</u>									
1. Coating Material Product Identification						_____	_____	_____	
2. Coating Material Acceptability						_____	_____	_____	
<u>COATING MIXING/THINNING OPERATIONS</u>									
1. Mixing						_____	_____	_____	
2. Thinning						_____	_____	_____	
<u>COATING MIXING/THINNING RECORD</u>									
<u>Material Identification</u>					<u>Satch Number</u>	<u>Weight or Volume</u>			
1.	_____				_____	_____			
2.	_____				_____	_____			
	(Filler/Cat./Sol.)				Volume (1.-2.+3.) =	_____			
3.	_____				_____	_____			
	(Solvent)				Volume (1.-2.+3.) =	_____			
Thin/Wind _____ s.m./p.m.					Pot Life Expires _____ s.m./p.m.				
Ambient Temperature _____ °F					(Approx)				